

This listing of claims will replace all prior versions and listings of claims in the application.

**Listing of Claims:**

1. (Canceled) A Method of preparing a z-filter media construction including steps of:
  - (a) providing a filter media combination comprising a fluted filter media sheet secured to a facing sheet of filter media with a first sealant strip therebetween against a first side of the facing sheet; and,
  - (b) forming a first coiled configuration by coiling the filter media combination with the facing sheet directed to the outside of the coil and with a second sealant strip, during coiling, positioned between the fluted filter media sheet and a second side of the facing sheet;
    - (i) at least one of the first sealant strip and second sealant strip comprising polyurethane sealant.
2. (Canceled) A method according to claim 1 wherein:
  - (a) the second sealant strip comprises polyurethane composition that increases in volume during cure.
3. (Canceled) A method according to any one of claims 1 and 2 wherein:
  - (a) the second sealant strip comprises polyurethane composition that increases in volume by at least 40%, during cure.
4. (Canceled) A method according to any one of claims 1-3 including a step of:
  - (a) positioning a housing seal on the first coiled configuration.
5. (Canceled) A method according to claim 4 wherein:
  - (a) the step of positioning a housing seal comprises positioning a framework on the filter media and a urethane housing seal on the framework.
6. (Canceled) A method according to claim 4 wherein:

- (a) the step of positioning a housing seal comprises securing a foamed polyurethane seal to an outer surface of the filter media.
7. (Canceled) A method according to any one of claims 1-6 wherein:
- (a) the step of forming a first coiled configuration comprises:
    - (i) coiling the filter media combination, with the second sealant strip positioned between the backside of the facing sheet and the fluted sheet, on a mandrel; and
    - (ii) removing a resulting coil from the mandrel to provide a coreless coil.
8. (Canceled) A method according to any one of claims 1-7 wherein:
- (a) the step of forming a first coiled configuration comprises coiling to form a circular coil.
9. (Canceled) A method according to any one of claims 1-8 including a step of:
- (a) distorting the first coiled configuration to a second coiled configuration before the second sealant strip is fully cured.
10. (Canceled) A method according to claim 9 wherein:
- (a) the step of distorting comprises distorting the circular coil to an obround shape.
11. (Canceled) A method according to claim 10 wherein:
- (a) said step of distorting comprises forming at least six interdigitized flutes along a center strip of the z-filter media construction, in the region of the second sealant strip.
12. (Canceled) A method according to claim 10 wherein:
- (a) said step of distorting comprises distorting to an obround coiled shape having two, opposite, sides and two, opposite, rounded ends.
13. (Canceled) A method according to claim 9 wherein:

- (a) the step of distorting comprises distorting such that the second sealant strip forms a central seal in the z-filter media construction.
14. (Canceled) A method according to claim 7 including a step of:
- (a) positioning foamed polyurethane in a space inside of the coreless coil to prevent unfiltered flow therethrough.
15. (Canceled) A method according to claim 14 including:
- (a) providing a foamed polyurethane housing seal gasket secured to the outer surface of the z-filter media construction.
16. (Canceled) A method according to any one of claims 1-15 wherein:
- (a) the facing sheet is a non-corrugated sheet.
17. (Canceled) A method according to any one of claims 1-16 including a step of:
- (a) applying the second sealant strip to the fluted sheet before coiling with:
    - (i) a selected amount of sealant applied a first distance from a nearest edge of the filter media combination at a first location of the filter media combination adjacent a lead edge of the strip;
    - (ii) a selected amount of sealant applied a second distance from the nearest edge of the filter media combination in a second location of the filter media combination following the first portion, the first distance being further than the second distance; and,
    - (iii) a selected amount of sealant applied a location of the filter media combination near a tail end and at a location further from a closest edge than the sealant on the second portion of the filter media combination.
18. (Canceled) A method according to any one of claims 1-17 wherein:
- (a) said step of coiling includes guiding an extension of the filter media combination into a media catch slot of a winding hub and winding the hub to coil the filter media combination.

19. (Canceled) A method according to any one of claims 1-18 wherein:
  - (a) said step of providing a filter media combination includes:
    - (i) corrugating a first sheet of media and securing it to a facing sheet with the first sealant bead therebetween; the first sealant bead being applied to the first sheet of media before corrugation.
20. (Canceled) A method according to any one of claims 1-19 wherein:
  - (a) said step of providing a filter media combination includes:
    - (i) positioning the first sealant strip mid-web; and
    - (ii) slitting a resulting media construction through the first sealant strip to provide the filter media combination to be used in the coiling.
21. (Canceled) A method of preparing a z-filter media construction including steps of:
  - (a) providing strips of filter media combination each comprising a fluted filter media sheet secured to a facing sheet of filter media with a first sealant strip therebetween; and,
  - (b) stacking the strips of corrugated sheet/facing sheet with a second sealant strip applied therebetween;
    - (i) at least one of the first sealant strip and second sealant strip comprising a polyurethane sealant.
22. (Canceled) A z-filter media construction made according to one or more of claims 1-21.
23. (Canceled) A z-filter media construction comprising:
  - (a) a coiled media pack comprising a coiled media combination of fluted media secured to facing sheet;
    - (i) the media pack having first and second opposite flow faces and comprising a first set of inlet flutes and a second set of outlet flutes;
    - (A) the inlet flutes being open to passage of unfiltered air therein, at the first flow face and being closed to unfiltered air therefrom at the second flow face;

- (B) the outlet flutes being closed to passage of unfiltered air therein at the first flow face and open to passage of filtered air therefrom at the second flow face;
  - (C) the fluted sheet being secured to the facing sheet on at least one side of the facing sheet by a continuous strip of polyurethane foam sealant applied before the media sheet becomes coiled.
24. (Canceled) A method of preparing a z-filter media construction including steps of:
- (a) coiling a corrugated sheet/facing sheet strip on a hub;
  - (b) removing a resulting coil from the hub to provide a coreless coil; and,
  - (c) sealing a center of the coreless coil closed with a polyurethane that increases in volume by at least 40% during cure.
25. (Canceled) A z-filter media construction made according to the method of claim 24.
26. (Canceled) A method of preparing a z-filter media construction including steps of:
- (a) coiling a corrugated sheet/facing sheet strip on a hub;
  - (b) removing a resulting coil from the hub to provide a coreless coil; and,
  - (c) distorting the coreless coil to an obround shape by pressing on a side area of the coil comprising facing sheet.
27. (Canceled) An obround z-filter media construction made according to the process of claim 26.
28. (New) A method of preparing a z-filter media construction including steps of:
- (a) coiling a corrugated sheet/facing sheet strip on a hub;
  - (b) removing a resulting coil from the hub to provide a coreless coil; and,
  - (c) distorting the coreless coil to an obround shape by pressing on a side area of the coil comprising facing sheet.
29. (New) A method according to claim 28 wherein:

- (d) the step of coiling comprises winding a corrugated sheet/facing sheet strip including a urethane backside sealant bead.
30. (New) A method according to claim 29 wherein:
- (e) the step of coiling comprises forming a generally circular coil.
31. (New) A method according to claim 30 wherein:
- (f) the step of distorting the coreless coil to an obround shape comprises distorting to a shape having two opposite, rounded, ends.
32. (New) A method according to claim 31 wherein:
- (g) the step of distorting the coreless coil to a shape having two opposite, rounded, ends involves distorting to a shape also having two, opposite, straight sides.
33. (New) A method according to claim 32 wherein:
- (h) the step of coiling comprises winding a corrugated sheet/facing sheet including a urethane backside sealant bead that foams.
34. (New) A method according to claim 33 wherein:
- (i) the step of coiling comprises winding a corrugated sheet/facing sheet including a urethane backside sealant bead that comprises a urethane that increases in volume by at least 40% during care.
35. (New) A method according to claim 34 including a step of:
- (j) sealing a tail end of the media along its length by a sealant.
36. (New) A method according to claim 35 including a step of:
- (k) sealing a tail end of the media along its length by a hot melt sealant.
37. (New) A method according to claim 34 including a step of:
- (l) positioning a housing seal on an obround shaped coil resulting from the step of distorting.

38. (New) A method according to claim 37 wherein:
  - (m) the step of positioning a housing seal comprises securing a polyurethane seal to an outer surface of the filter media.
39. (New) A method according to claim 37 including a step of:
  - (n) mounting a framework on the obround shaped coil resulting from the step of distorting.
40. (New) A method according to claim 39 including a step of:
  - (o) providing a housing seal ring on the framework.
41. (New) A method according to claim 40 wherein:
  - (p) the step of mounting a framework includes mounting a plastic cross piece positioned as a face lattice.
42. (New) A method according to claim 41 wherein:
  - (q) the step of distorting comprises distorting to yield an obround shape with a straight side and with a tail end of the media along the straight side.
43. (New) A method according to claim 42 wherein:
  - (r) the step of distorting the coreless coil comprises forming at least six interdigitized flutes along a center strip of the z-filter media construction.
44. (New) A z-filter media construction prepared according to the method of claim 28.
45. (New) A z-filter media construction prepared according to the method of claim 40.
46. (New) A z-filter media construction comprising:
  - (s) a coreless coil of corrugated sheet/facing sheet having a backside sealant bead of urethane;
  - (i) the coreless coil having an obround shape with two opposite curved ends; and,

- (t) a framework mounted on the coreless coil at an end of the coreless coil and with a portion of the framework surrounding an end of the coreless coil;
    - (i) the framework including a housing seal ring thereon.
47. (New) A z-filter media construction according to claim 46 wherein:
- (u) the housing seal ring defines an outer shape with:
    - (i) a first end with curved corners;
    - (ii) a second end opposite the first curved end having curved corners and wider outer dimension than the first end; and
    - (iii) first and second, opposite, straight sides extending between the first and second ends.